



PREMIER AVIATION, INC.
1000 Airport Parkway, Grand Prairie, Texas 75050
DATE ISSUED: 04/10/04 DATE TO: 04/10/05
ITEM: D OSUV8 B67-43001 B4
SCALE: 1:1 ENTRY 14 OF 45

ORIGINAL

Date: Wednesday, 29/10/2008 8:10:53 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADJUSTABLE ATTACHMENT ARM ASSY

Job Number: 43054

Part Number: PB674300159

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

NAS1149F0332P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

batch: 18057

P 8/4/10

21.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- take -267 and transfer drill holes in -113 as per dwg PB67-43001

2- deburr and rivet -267 to -113 as per dwg

3- assemble rest of parts as per dwg PB67-43001

SAN 08-11-17

(2)

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 446B

N 08/11/20 (2)

24.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

M 08/11/21 (2)

Job Completion



MF 08-11-20

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Drawing Name: ADJUSTABLE ATTACHMENT ARM ASSY

Job Number: 43054

Part Number: PB674300159

Job Number:



Seq. #:	Machine Or Operation:	Description :
13.0	PB6743001267	PB67-43001-267
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) PB67-43001-267 batch: <u>41497</u>
14.0	PB6743001121	Square Sleeve
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Square Sleeve batch: <u>41866</u>
15.0	BSP43	RIVET Logilco Comment: Qty. 1 6.0000 Each(s)/Unit Total : 12.0000 Each(s) RIVET batch: <u>M109119</u>
16.0	MS17984C413	PIN, QUICK RELEASE
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) PIN, QUICK RELEASE batch: <u>M18119</u>
17.0	30345T21	LANYARD
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) LANYARD batch: <u>17828</u>
18.0	MS27039122	SCREW
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) SCREW batch: <u>18057</u>
19.0	MS21042L3	Nut
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) Nut batch: <u>M109031</u>

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Job Number: 43054

Part Number: PB674300159

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 M6061T6T1750W065

6061T6 RDTUBE 1.750 X 0.65W



Comment: Qty.: 0.1575 f(s)/Unit Total : 0.3150 f(s)

6061T6 RDTUBE 1.750 X 0.65W

batch: M 18489

(2X)

SP 08.11.02

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: 1- to make -105 take M6061T6 tube and fabricate to fit contour of cut SP

2- Weld -105 to -113 as per dwg and grind weld flush SP

3- weld 119, -117 and -115 to -113 as per dwg PB67-43001 SP

4- pick two -271 and weld one on each side of tubing but only one need to be trim to fit on -113 as per dwg PB67-43001

(2X)

SP 08.11.05

8.0 QC9

VISUAL WELDING INSPECTION



Cpl 08.11.05 BE

(2X)

Comment: VISUAL WELDING INSPECTION

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08.11.05 (2)

10.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

(2)

Fx 08/11/07

11.0 POWDER COATING

POWDER COATING



M 102316

(2X)

Comment: POWDER COATING

1- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

10:30

START TIME:

OF

OVEN TEMPERATURE:

320

FINISH TIME:

11:00

M 08/11/10

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08 - 11 - 11

(2X)

Date: Wednesday, 29/10/2008 8:10:53 AM
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Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: ADJUSTABLE ATTACHMENT ARM ASSY		
Job Number	: 43054						
Estimate Number	: 13479						
P.O. Number	:			Part Number	:	PB674300159	
This Issue	: 29/10/2008	S.O. No.	:	Drawing Number	:	B6743001 P.14	
Prsht Rev.	:	NC		Project Number	:	N/A	
First Issue	:	/ /	Type	Drawing Revision	:	B1	
Previous Run	:	41383		Material	:		
Written By	:			Due Date	:	05/11/2008	Qty: 2 Um: Each
Checked & Approved By	:	<u>JMF 08-10-29</u>					
Comment	:	Est Rev:A 08-07-18 new issue DD verified by:ec					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PB6743001113	Square Tubing	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Square Tubing batch: <u>B41477</u>	(2x) <u>JMF 08-11-04</u>
2.0	PB6743001119	End Cap Clevis	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) End Cap Clevis batch: <u>B 23991 x1, 40016 x1</u>	(2x) <u>JMF 08-11-04</u>
3.0	PB6743001117	Hook Plate	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Hook Plate batch: <u>41865</u>	(2x) <u>JMF 08-11-04</u>
4.0	PB6743001115	Tube End Plate	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Tube End Plate batch: <u>40014</u>	(2x) <u>JMF 08-11-04</u>
5.0	PB6743001271	Doubler	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) Doubler batch: <u>41493</u>	(2x) <u>JMF 08-11-04</u>